Packaging

January-10-13 11:03:44 AM Item ID: D2966-1-BENT Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Skidtube Assembly 105 **Start Date:** 1/10/13 Start Qty: 4.00 **Cust Item ID:** Required Date: 1/24/13 Req'd Qty: 4.00 **Customer:** Reference: Run Approvals: Process Plan: MC5 Date: 13-0/-/O Tooling: Date: QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D2966 Rev A 0.00 BENDING MACHINE - SKIDTUBES 120\* GNC Bend 1 0.00 Memo De 13/06/19 CNC Delta 100 Bender 1-Bend tube as per program BO105 on CNC Bender and Dwg D2966. Bend folio #1 use bending aid DT9631 2-Cut Fwd end of the tube using DT8185-1 QC5- Inspect part completeness to step on W/O 0.00 0.00 Memo Quality Control Identify as per dwg & Stock Location: 300 0.00 Packaging \*300\* Packaging 0.00 Memo

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Date	e:
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No						Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	l .	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	Α	action	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief Eng	Des	scription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator	Ш											
Material	Щ			ļ								
Setup	Ш											
Other	Ш											
Process	Ш											
Supplier	Ш											
Training												
Unapproved	Ш	<u> </u>	<u> </u>		1		TALLIT CAT	CORY				
l a sadi							AULT CAT	EGORY				
Landi		Bending				General Bend	Grain		<u></u>	Ovalized	Г	Pressure/Forced
	-	Centre No	ot Conco	ntric to	O/s	BOM/Route	Hardw	ara		Over/Under	toloranco	Temperature/Cure
	-	Cracks	ot concei	iitric to	<sup>0/3</sup>  -	Broken/Damaged	<b>  </b>	tion Incomplete	-	Part Incorre		Weld
	-	Crushed/	Crimped		ii –	Burrs	<b></b>	ctions Incomplete	a/Unclear	Part Lost/M	<b>⊢</b>	Wrong Stock Pulled
	-	Cuffs	crimpea.	-	$\vdash$	Contamination	<del></del>	enance	- Criclear	Part Moved	- L	Wrong Stock runeu
	Н	Heat Trea	at		<u> </u>	Countersink	Mislat		<u> </u>	Positioned \		
	$\vdash$	Inspectio		Tube	<del> </del>	Cut Too Short	Misrea			Power Loss,		Other
	-	Ripples in	•		F	Drill Holes	Offset			1. 2 2333,		12.10.
	-	Torque W		extrusio	n ⊨	Drawing	$\vdash$	Calibration				
	-	Turning S				Finish	Out of Sequence					
Wave/Twist in Tube			Folio	$\vdash$	e Dimensions							

January-10-13 11:03:44 AM Item ID: D2966-1-BENT Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Skidtube Assembly 105 **Start Date:** \*4\* 1/10/13 Start Qty: 4.00 **Cust Item ID:** Required Date: 1/24/13 Req'd Qty: 4.00 **Customer:** Reference: Run Date:\_\_\_\_\_ Process Plan: Approvals: Tooling: Date: Stop Date:\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 310 QC21- Final Inspection - Work Order Release 0.00 \*310\* QĊ 0.00 Memo Quality Control

127-1

															DQA:	D	ate: _	
NCR:	Yes	/ No				WOR	K ORDE	R NON-C	ON	IFORM	MANCE / L	JPDA	<b>NTE</b>		·			
											-				QA Closed:	D	ate:	
Work Ord							DISPOSI	TION					AGAINST	DE	PARTMENT	PROCESS		
Work Orac	er							Rework	1 <b> </b>	Chick with a Connection of					Water Je	Engineering		
Dort 1	u a							<u> </u>			Skid-tube Machining	-	Crosstube Small Fab		Dro	d. Eng. Cooi	$\vdash$	Quality
Part I	۷O							Scrap Jse-as-is			noforming	-	Finishing			e/Packagin	-	Other
NCR I	No.					1	ork Order				Large Fab	┨ ,	Composite		nec/3to	Supplie	~ —	
NCIVI	٠٠		<u> </u>			"	JIK OIGEI	opuate	¹		raige rab	_ `	composite			Supplie	.П	
Root				_	Descr	iption of v	work orde	er update	11	nitial _		Actio	n ,		Sign &			
Cause		Date	Step	Qty		or Non-co	onforman	ce	Chi	ief Eng	De	escript	tion		Date	Verificati	on	QC Inspector
Doc/Data						•	0											
Equip/Tooling					`													
Operator																		
Material							•											
Setup											:						-	
Other		:															]	
Process	Ш								l									
Supplier							,											
Training	Ш																	
Unapproved					<u> </u>							. <u></u>						
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Landi	ng G	iear				٠,	General		_				1	_	,			•
		Bending			_	Bend				Grain					Ovalized			Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Ro			$\vdash$	Hardwa				L	Over/Under			Temperature/Cure
		Cracks				Broken/	/Damaged	4	-		on Incomplete			L	Part Incorre			Weld
	Ш	Crushed/0	Crimped.			Burrs			Ш	Instruct	ions Incomple	te/Und	clear	L	Part Lost/M	issing		Wrong Stock Pulled
Cuffs			Contami	nation		1	Maintenance			1	Part Moved							

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## -Picklist Print

January-10-13 11:03:48 AM

Work Order ID: 95510

\*95510\*

Location

HALL

Parent Item:

D2966-1-BENT

\*D2966-1-RFNT\*

Parent Item Name: Skidtube Assembly 105

**Start Date:** 1/10/13

Required Date: 1/24/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 10.09.17 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D2962-125		Manufactured	No				Each	9.0000		4				•
*D2962-12	5*								**	ni	2/2/	/ - 3		

Outer Tube Extrusion

Loc Code Loc Qty

17532

									DQA:	Date:			
NCR: Yes	/ No				WORK ORDER NON-C	CONFORM	MANCE / UF		QA Closed:	Date:			
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.					Rework Scrap Use-as-is Work Order Update	]   '	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Prod Rec/Stor	Engineering Quality Other			
Root				Descri	ption of work order update	Initial	A	ction	Sign &				
Cause	Date	Step	Qty	·	or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector		
Ooc/Data  Equip/Tooling Operator Material Setup Other Process Supplier			,										

**FAULT CATEGORY Landing Gear** General Bend Pressure/Forced Bending Grain Ovalized Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Inspection Incomplete Cracks Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Mislabeled Positioned Wrong Heat Treat Countersink Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Out of Calibration Drawing Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





	DESIGN RF	DRAWN BY	DART AEROSPACE US	SA, INC.
	CHECKED	APPROXED	DRAWING NO.	REV. A
-	#		D2966	SHEET 1 OF 2
	DATE	,	TITLE	SCALE
	00.03.	08	BO 105 SKIDTUBE ASSEMBLY	ŅTS
	Α	00.03.08	NEW ISSUE	



Qty	Part Number	Description
Х	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130	INSERT
	or ALS4-1032-130	
	or AKS7-1032-130	
	or AKS4-1032-130	
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
ı	D3176-1	Bushing
ł	D3176-3	Nut

## A2

## **GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL)

BLACK SHAPTEY (REF 4.3.5.7)

# 01.01.29

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MLJ		4	γPY	

AZ	02.10.30	MOD	03176-	1/-	3	#4
ΑI	01.01.29	CHANGE	LOLOR	to	BLACK	SAMOTEX + P

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